

Work Order ID 124881

124881

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Thursday, September 25, 2014 1:07:11 PM

Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R *OK Dm/aps* Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
 Tri-Bag Float Comp
 Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 10-09-25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274-041	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D206-642-541		CHG005						

N/A *[Signature]*

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
 Tri-Bag Float Comp
 Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110	Skidtubes	Memo							
Skidtubes	****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: <u>M125127</u> 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.								

DGL 14-9-29

7814-09-29

DGL 14-9-30

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[illegible]

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Stop ***NS2***
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00				/	/	14-10-01	BE/ DGL
Quality Control									
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <u>129457</u>								
	Sikaflex expire date: <u>14-11-20</u>								
	Start: _____ Time: _____								
	Finish: _____ Time: _____								
	(Adhere for 12 hours)								

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Dura Hammer	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170		0.00							
170	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.								
	2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr								
	3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES								
	4- Countersink crossbolt spacer holes as per Dwg D3274								
	5- prepare for welding								

DAS 03 9-88 14-10-2

14-10-2

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Accept

N900040100

Setup Start *NS1*

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 9/25/2014 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 9/25/2014 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID
180

Operation	Description
QC5-	Inspect part completeness to step on W/O

Set Up/ Run Hours	Tool
0.00	4.6° 3.060"

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept
Qty

Reject
Qty

Reject Number	Insp. Stamp
------------------	----------------

**DAS
18
9-89**

180

QC

Memo

0.00

Quality Control

190

0.00

190

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod m 125127

8E14-10-03

3-Grind cross bolt welds flush as per Dwg D3274. *DEC 14-10-06*

Doc 14-10-06

*****INSPECT FOR PIN HOLES IN WELD*****

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

14-10-7

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Item ID: D206-642-541 **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: U/R **Stop *NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Start Date: 9/25/2014 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 9/25/2014 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ DAS Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 16 9-89 14/10/08					
210 *210* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		DAS 16 9-89 14/10/08					
220 *220* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch	0.00 0.00							1x of 14/10/09

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Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230						1			CR 14.10.21
SprayPaint	Memo	0.00							
Spray Painting	Make sure Nut Plate Thread is protected using paint screw.								
	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>128 975</u>								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>130 308</u>								
240	QC14- Inspect Spray Paint	0.00							
240									
QC	Memo	0.00							
Quality Control									
244	Wing Walk as per dwg QSI005 4.4 Batch <u>113 0285</u>	0.00							
244									
HandFinish	Memo	0.00							
Hand Finishing									

DAS
15
9-89

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Dwg Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
246	QC3- Inspect Part Finish	0.00							
246									
QC	Memo	0.00				1			DAS 38 9-89 14-10-27
Quality Control									
250	HandFinishing	0.00							
250									
HandFinish	Memo	0.00				1	4	20	11/10/24
Hand Finishing									

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON 11122900

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/RSikaflex-291 11130227

Sikaflex expire date: 15/08

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Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Insp.
Stamp

1 of 14-10-24. DAS 34 989

Quality Control

0.00

Memo	0.00
-------------	------

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/RSikaflex-291 4130277
Sikaflex expire date: 15/08

3-Inspect for foreign objects as per QSI 024

4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 14130227.
Sikaflex expire date: 15101

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 9/25/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/25/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Sequence ID/
Work Center ID**
280

Operation	Description
QC5-	Inspect part completeness to step on W/O

**Set Up/
Bus Home**
0.00

Tool ID	Tool #	Plan Code
---------	--------	-----------

Plan Code	Accept Qty
--------------	---------------

Reject
Qty

Reject Number

Insp. DAS
Stomach
38
9-89

280

OC

Memo

0.00

Quality Control

DAS
49
9-89

14/10/27

290

Identify as per dwg & Stock Location:

0.00

290

Packaging

Memo

0.00

Packaging

NOV 18 2011

DAS
86
9-89

300

QC21- Final Inspection - Work Order Release

0.00

300

OC

Memo

0.00

Quality Control

W 14.11.8

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Work Order ID: 124881

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC IPP
 REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I
 14.04.28 AS PER ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3274-041BENT

Manufactured No

110

Each

10.0000

1

1

D3274-041BENT

Skidtube Assembly 206

Location

Loc Qty

Loc Code

LG002

10

113682

1

120287

9

D4956-15

Manufactured No

270

Each

14.0000

1

1

D4956-15

Stainless Steel Wearplate Fwd

Location

Loc Qty

Loc Code

FP002

14

120326

2

122996

12

D4956-23

Manufactured No

270

Each

10.0000

1

1

D4956-23

Stainless Steel Wearplate Center Fwd

Location

Loc Qty

Loc Code

FP002

10

121755

10

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Work Order ID: 124881

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D4956-35 Manufactured No 270 Each 12.0000 Start Qty: 1.00 Required Qty: 1.00
1 1
****** lll 14/10/23

D4956-35

Stainless Steel Wearplate Aft

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	12	
120577	1	
121975	11	

D4956-39 Manufactured No 270 Each 9.0000 1 1
****** lll 14/10/23

D4956-39

Stainless Steel Wearplate Center Aft

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	9	
121857	9	

D3285-1 Manufactured No 110 Each 5.0000 1 1
****** BE 14-09-29

D3285-1

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	5	
108052	5	

D3282-041 Manufactured No 150 Each 7.0000 1 1
****** DGC 14-10-1

D3282-041

Float Web (206L/407)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	7	
113149	1	
119524	6	

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Parent Item: D206-642-541

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Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D2649 Manufactured No 190 Each 415.0000 12 12

Start Qty: 1.00

Required Qty: 1.00

D2649

Cross Bolt Spacer

BB 14-10-02

Location	Loc Qty	Loc Code
LG	203	
<u>123099</u>	203	<u>12</u>
LG001	212	
107906	3	
112728	6	
113811	2	
120508	195	
90497	6	

D3275-1 Manufactured No 190 Each 191.0000 12 12

D3275-1

Crossbolt Spacer

BB 14-10-02

Location	Loc Qty	Loc Code
LG001	191	
113246	1	
113851	62	
<u>114877</u>	65	<u>12</u>
121868	1	
121974	62	

CR3212-4-03 Purchased No 250 Each 998.0000 2 2

CR3212-4-03

Cherry Rivet

20 11/10/23

Location	Loc Qty	Loc Code
ST321	998	
114889	1	
119017	700	
m114859	100	
<u>m123265</u>	197	<u>12</u>

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3415-041 Manufactured No

250 Each

Start Qty: 1.00
19.0000 1 1

Required Qty: 1.00

D3415-041

Nut Plate

**

ll 11/10/23

Location

Loc Qty

Loc Code

ST037

19

113764

19

x1

CCR264SS3-3

Purchased No

250 Each

431.0000 2 2

CCR264SS3-3

Cherry Rivet

**

ll 11/10/23

Location

Loc Qty

Loc Code

ST321

431

113973

26

m126282

47

m126333

70

x2

m128636

88

m128818

200

ALS4-1032-130

AELS4-1032-130 Purchased No

250 Each

4,073.000 78 78

ALS4-1032-130

Rivnut

**

ll 11/10/23

Location

Loc Qty

Loc Code

ST267

4073

M126109

57

M128211

48

M128649

3968

y78

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3537-3

Manufactured No

270

Each

60.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

D3537-3

Wearpad

Handwritten: 11/10/23

Location

Loc Qty

Loc Code

FG

8

86237

8

FP001

12

111825

1

113789

1

115122

10

FP002

40

120646

40

Handwritten: v1

D3537-1

Manufactured No

270

Each

78.0000

9

9

D3537-1

Wearpad

Handwritten: 11/10/23

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

60

113839

4

120644

37

120645

18

93945

1

Handwritten: B124485

Handwritten: v9

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Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

NAS1149C0332R

Purchased

No

270

Each

Start Qty: 1.00
8,181.000 80 80

Required Qty: 1.00

NAS1149C0332R

WASHER

**

14/10/24

Location

Loc Qty

Loc Code

CA	83	
m129682	83	
ST278	8098	
122063	41	
125654	473	
m126319	61	
m127306	2065	v80
m127410	166	
m127831	26	
m128591	75	
m129499	191	
m130325	5000	

NAS1149C0463R

Purchased

No

270

Each

622.0000 1 1

NAS1149C0463R

Washer

**

14/10/24

Location

Loc Qty

Loc Code

ST278	622	
119097	1	
123248	1	
123355	55	
m127306	125	x1
m128401	440	

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Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3672-1 Manufactured No

270 Each

Start Qty: 1.00
955.0000 2 2

Required Qty: 1.00

D3672-1

Washer, Phenolic

ll 10/10/24

Location	Loc Qty	Loc Code
FG	10	
85222	10	
ST055	945	
103845	4	
113581	474	
120116	421	
80369	34	
99099	12	

x2

AN3C4A Purchased No

270 Each

1,103.000 80 80

AN3C4A

Bolt

ll 10/10/24

Location	Loc Qty	Loc Code
FG	20	
122814	20	
ST350	1083	
124221	12	
M127410	1	
M127832	62	
M128606	32	
M128634	8	
M128739	4	
M128879	71	
M129520	893	

x80

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Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

AN4C5A

Purchased

No

270

Each

56.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

AN4C5A

Bolt

**

lll 9/10/2014

Location

Loc Qty

Loc Code

ST355

56

122599

3

123265

1

M127410

10

M128403

42

✓

D2646

Manufactured

No

270

Each

57.0000

1

1

D2646

Aft Cap

**

lll 9/10/2014

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

12

103306

2

107857

1

110816

1

113830

2

114495

6

FP002

41

119656

41

✓

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Work Order ID: 124881

124881

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3413-1

Manufactured No

270

Each

33.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

D3413-1

O-Ring

Handwritten signature and date 9/10/2014

Location

Loc Qty

Loc Code

ST525

33

106048

1

110715

11

112309

6

114489

3

114528

1

116664

1

120218

10

VI

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2800-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2648	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D4856-15	WEARSHOE
1	1	D4856-23	WEARSHOE
1	1	D4856-35	WEARSHOE
1	1	D4856-39	WEARSHOE
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN860C416	WASHER
80	80	AN860C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
6. IDENTIFICATION: N/A
7. WEIGHT: 20.8 LBS
8. WELDING TO BE DONE PER DART QSI 004.
9. ALL HOLES DRILLED ON CENTERLINES.
10. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/281.
13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.



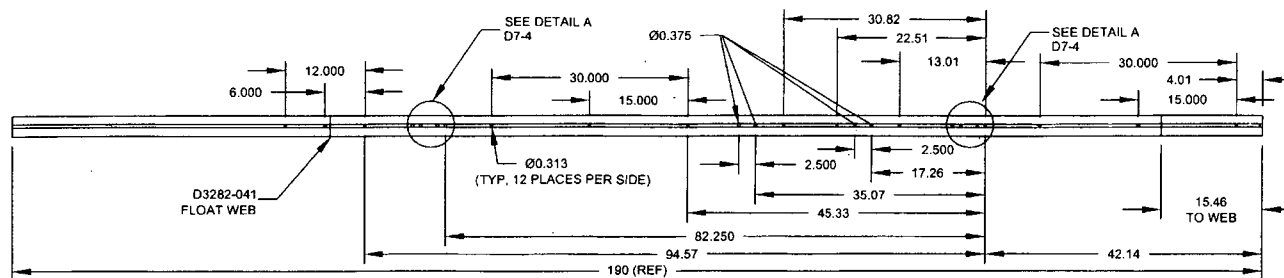
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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 124881 MWS

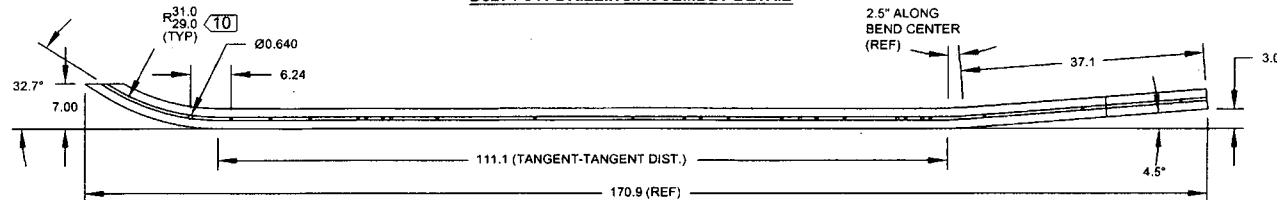
14-09-25

RELEASED
2014-05-26
m

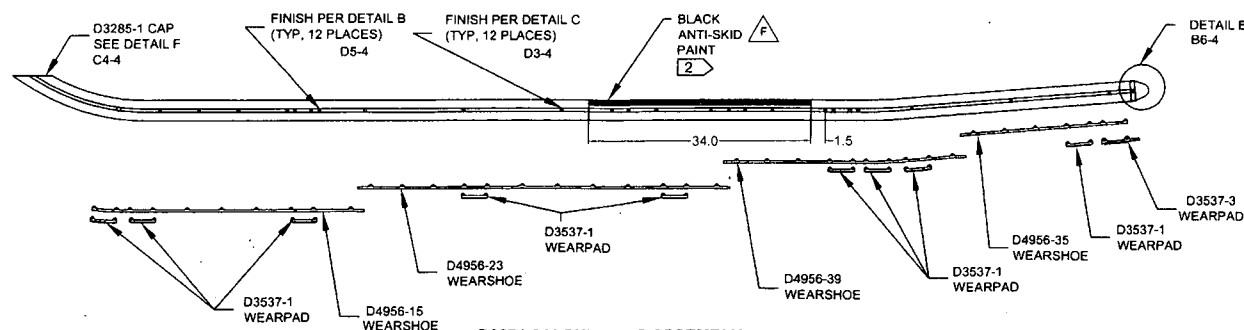
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D208-042 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043; NEW INSERTS	CP	05.03.16
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD	



D3274-041 DRILLING/ASSEMBLY DETAIL



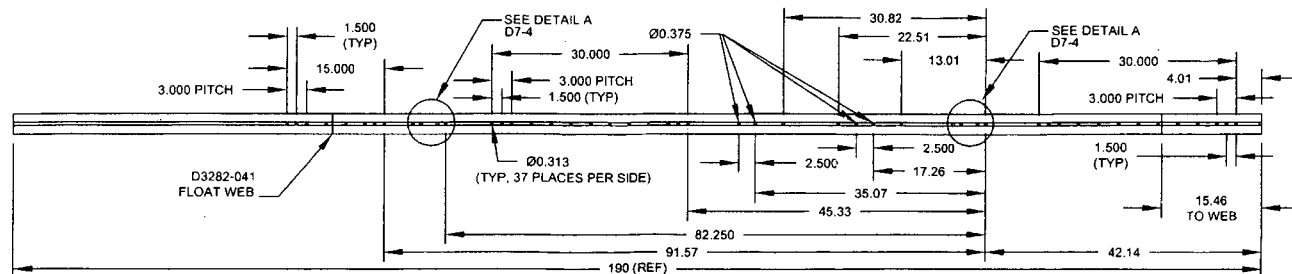
D3274-041 BEND/DRILLING DETAIL



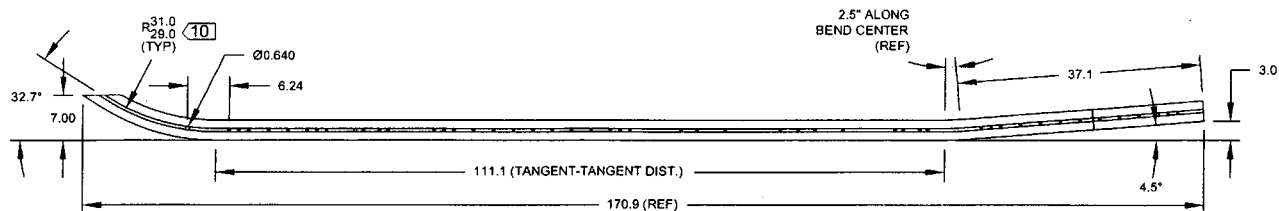
**D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

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2014-05-26

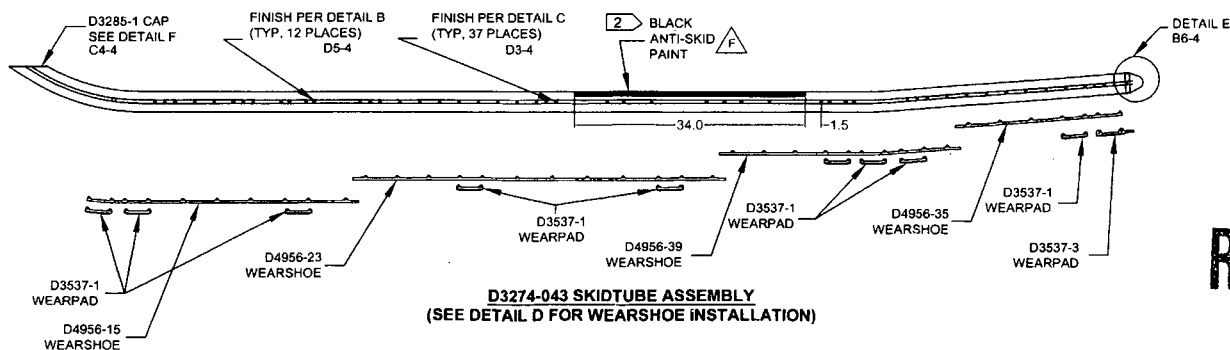
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DRAWN	DB		
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MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 2 OF 4
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D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL

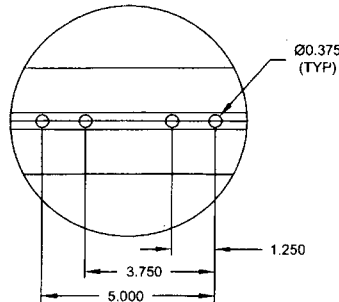


**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

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2014-05-26

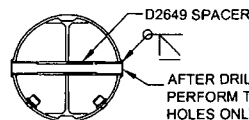
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DRAWN	DB	KENT, WA	
CHECKED	<i>DB</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE ASSEMBLY	4.04.15
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DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

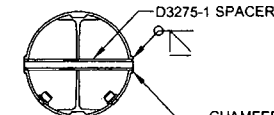
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

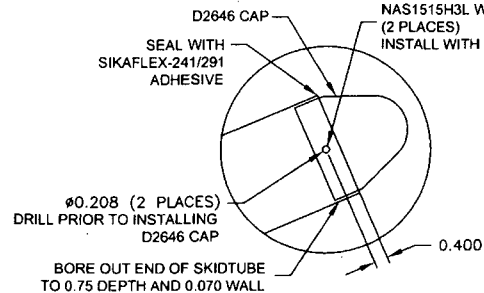
DETAIL D
A4-2, A4-3



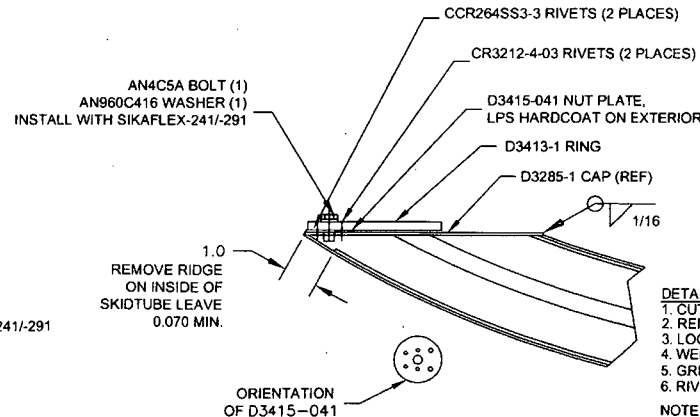
ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASE
2014-05-26

DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DB		
CHECKED	g.p.	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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elle

Mike Petsche
June-24-14 3:17 PM
Linda Lacelle
RE: D206-642-541 floats

I say just assemble them. The powder coat won't last long anyway

a Lacelle
ay, June 24, 2014 12:40 PM
tsche; David Shepherd; Chris Provencal
rbes
E: D206-642-541 floats

ed with assembly? We have about 10 on the go right now. I really don't want to wait to have more made...we have 79 of the painted in stk of D3537-
the D3537-3's. shall I get all the w/o's off the shop floor and remove the powder coat? Do I need someone to sign this off?

Petsche
24-14 12:38 PM
acelle; David Shepherd; Chris Provencal
rbes
E: D206-642-541 floats

eally. But ideally we should remove the powder coat from the dwg

i Lacelle
ay, June 24, 2014 12:36 PM
epherd; Mike Petsche; Chris Provencal
rbes
206-642-541 floats

anyone that can answer me:
arplates D4956-XX that replace the D3535-XX are SS unpainted, but the wearpads D3537-1/-3 are painted, does this matter?